



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D212-664-207

Job Sheet 195636



Rework

Part No: D212-664-207

Job Qty: 1 pcs

Part Name: Aft Crosstube - Low Standard



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/28/19

Job Tracking No:

Due Date: 6/11/19

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV D/ IIN-D212-664 REV.J IPP Rev:A New Issue 07.09.12 EC verified by: JLM IPP Rev:B ECN 1100p
08-01-11 DD verified by: EC IPP Rev:C ECN 1121 08-02-25 DD verified by:eC IPP Rev: D QC5 replaced by
QC15 at step 5 KJ Verified by: ec

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	1 pcs		6/11/19	0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		AB 17-5-29
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		

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Container No: S184896



Part: D212-664-207

Job No: 195636

Serial No/Batch: S184896

D212-664-207/01 155967/195636/5184896

					Packaging 1 - 31	
					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
					Packaging 1 - 36	
210	Crosstubes - 4 - B4B	1 pcs	6/11/19	0.00 2.00	Crosstubes - 1 - B4B	
					Crosstubes - 2 - B4B	
					Crosstubes - 3 - B4B	
					Crosstubes - 4 - B4B	• A8 19-5-29
215	QC 5	1 pcs	6/11/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	DAS
					QC 5 - 43	19
					QC 5 - 49	9-60
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
220	Spray Paint - 2 - B4B	1 pcs	6/11/19	0.00 0.33	Spray Paint - 1 - B4B	• R0 19-5-30
					Spray Paint - 2 - B4B	
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
230	QC 14	1 pcs	6/11/19	0.00 0.00	QC 14 - 15	
					QC 14 - 2	
					QC 14 - 34	
					QC 14 - 41	A 17-6-1
					QC 14 - 51	
					QC 14 - 58	
					QC 14 - 59	
					QC 14 - 9	
					QC 14 - 68	
					QC 14 - 40	
					QC 14 - 19	
					QC 14 - 43	
					QC 14 - 24	
240	Crosstubes - 5 - B4B	1 pcs	6/11/19	0.00 2.00	Crosstubes - 1 - B4B	
					Crosstubes - 2 - B4B	
					Crosstubes - 3 - B4B	
					Crosstubes - 4 - B4B	• A8 19-6-1
250	QC 5	1 pcs	6/11/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	

					QC 5 - 58		
					QC 5 - 68	JUN 03 2019	DAS 68
					QC 5 - 9		9-89
					QC 5 - 50		
					QC 5 - 30		
					QC 5 - 40		
255	Packaging 1-1 - Pick Kit - B4B	1 pcs	6/11/19	0.00 0.00	Packaging 1 - 1 - B4B		
					Packaging 1 - 2 - B4B		
					Packaging 1 - 3 - B4B		
					Packaging 1 - 4 - B4B		
					Packaging 1 - 5 - B4B		
					Packaging 1 - 6 - B4B		
					Packaging 1 - 7 - B4B		
					Packaging 1 - 8 - B4B		
					Packaging 1 - 9 - B4B		
					Packaging 1 - 10 - B4B		
					Packaging 1 - 11 - B4B		
					Packaging 1 - 12 - B4B		
					Packaging 1 - 13 - B4B		
					Packaging 1 - 14 - B4B		
					Packaging 1 - 15 - B4B		
					Packaging 1 - 16 - B4B		
					Packaging 1 - 17 - B4B		
					Packaging 1 - 18 - B4B		
					Packaging 1 - 19 - B4B		
					Packaging 1 - 20 - B4B		
					Packaging 1 - 21 - B4B		
					Packaging 1 - 22 - B4B		
					Packaging 1 - 23 - B4B		
					Packaging 1 - 24 - B4B		
					Packaging 1 - 25 - B4B		
					Packaging 1 - 26 - B4B		
					Packaging 1 - 27 - B4B		
					Packaging 1 - 28 - B4B		
					Packaging 1 - 29 - B4B		
					Packaging 1 - 30 - B4B		
					Packaging 1 - 31 - B4B		
					Packaging 1 - 32 - B4B		
					Packaging 1 - 33 - B4B		
					Packaging 1 - 34 - B4B		
					Packaging 1 - 35 - B4B		
					Packaging 1 - 36 - B4B		
260	QC 4	1 pcs	6/11/19	0.00 0.00	QC 4 - 28		
					QC 4 - 58		
					QC 4 - 69		
					QC 4 - 9		
					QC 4 - 46		
					QC 4 - 68		
					QC 4 - 72		
					QC 4 - 74		
270	Packaging 3-1 - Stock - B4B	1 pcs	6/11/19	0.00 0.00	Packaging 3 - 1 - B4B		
					Packaging 3 - 2 - B4B		
					Packaging 3 - 3 - B4B		
					Packaging 3 - 4 - B4B		
					Packaging 3 - 5 - B4B		
					Packaging 3 - 6 - B4B		
					Packaging 3 - 7 - B4B		
					Packaging 3 - 8 - B4B		
					Packaging 3 - 9 - B4B		

					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	DAS
					Packaging 3 - 36 - B4B	21 JUN 2 1 2019
275 DC - 1 - B4B	1 pcs	6/11/19	0.00 0.00		DC - 1 - B4B	9:59
					DC - 2 - B4B	
280 QC 21 - FG	1 pcs	6/11/19	0.00 0.00		QC 21 - FG - 21	DAS
					QC 21 - FG - 70	21
					QC 21 - SA - 53	9:59

Part Op 110 - PICK KIT

Descriptions: **210** - Crosstubes *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** 1-Rivet and assemble Cuffs with T-Pin in the through bolt holes as per Dwg D212-664-247. with Sika flex in Between tube & Cuff
215 - QC5- Inspect part completeness to step on W/O *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***
 Inspect cuff with T-Pin
220 - Spray Paint / NDT Room *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Clear 5151467
 PRIMER: 5154137 START TIME: FINISH TIME: PAINT: 5194740
230 - QC14- Inspect Spray Paint - Wrap in plastic bag to protect from scratches
240 - Crosstubes - 1- Assemble as per Dwg D212-664-247 2- Install supports with Proseal 890 per D212-664-247 and QSI 015 3- Install clamps with rubber cushion (ENSURE CLAMPS ARE INSTALL ON TOP SIDE OF CROSSTUBE) as per Dwg D212-664-247.
250 - QC5- Inspect part completeness to step on W/O - ***RE-CHECK TORCQUE ON CLAMP AFTER PROSEAL HAS CURED FOR 72HOURS AS PER DWG.***
255 - Pick Kit
260 - QC4- 100% Inspect kits for completeness ***VERIFY BY _____ BATCH # TO MATCH W/O
270 - Identify as per dwg & Stock Location: _____ Identify and pack for shipping as per PPP D212-664-207
275 - Document Control - Photocopy bluefile and create labels as per PPP D212-664-207 CHG003
280 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D212-664-207	Aft Crosstube - Low Standard	1 pcs (1 ea)	110-Packaging 1 - Pick Kit	
MS21920-28	Clamp	4 Ea (4 ea)	240-Crosstubes - 5 - B4B	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	D212-664-207 155967	④	0	0
240-Crosstubes - 5 - B4B	MS21920-28 5171291	④	146	0

Part Specifications
Specifications could not be found.

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Description: CROSSTUBE INSTALLATION, LOW AFT

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